

Work Order ID 69157

Tuesday, May 03, 2011 1:35:43 PM



Page 1

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Upper Rib Assembly

Start Date: 5/3/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 1/08-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4034	B								

100 Weld per dwg A/R S.S. rod Batch: ~~11578~~ 0.00



Large Fab

Memo 0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo 0.00

Quality Control

Swloglog

~~11.05.29~~ (10)

11.06.08 (3)

11.06.08

(3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D4034-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Upper Rib Assembly					
Start Date:	5/3/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	5/17/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WAG</i>	0.00							
	Packaging								
Packaging	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

11-06-14 *(3)*

11/6/14 *J*

MF *14*

11-06-14

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 1:35:49 PM

Page 1

Work Order ID: 69157

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly




Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1  Rib		Manufactured	No			100	Each	22.0000	1	3			
<div> <div>Location</div> <div>WA006</div> <div>67271</div> </div> <div> <div>Loc Qty</div> <div>22</div> <div>22</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4034-3  Rib		Manufactured	No			100	Each	6.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>58408</div> <div>67269</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>0</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D4021-7  Hoop		Manufactured	No			100	Each	10.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>56996</div> <div>67268</div> <div>WA005</div> <div>68090</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>0</div> <div>4</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

SAD 11-06-07

3

SAD 11-06-07

3

SAD 11-06-07

B691637 → (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 1:35:49 PM

Page 2

Work Order ID: 69157

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-9

Manufactured No

100

Each

96.0000

4

12



Bushing



SAD 11-06-07

Location

Loc Qty

Loc Code

WA

64

68063

64

WA005

32

66437

32

⑥

⑥

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

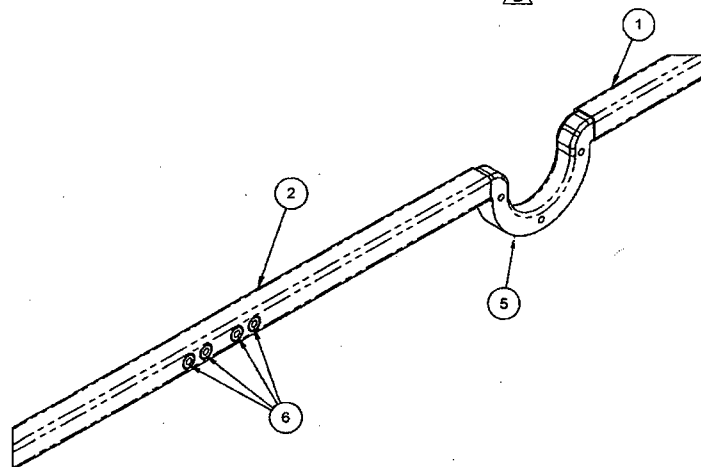
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

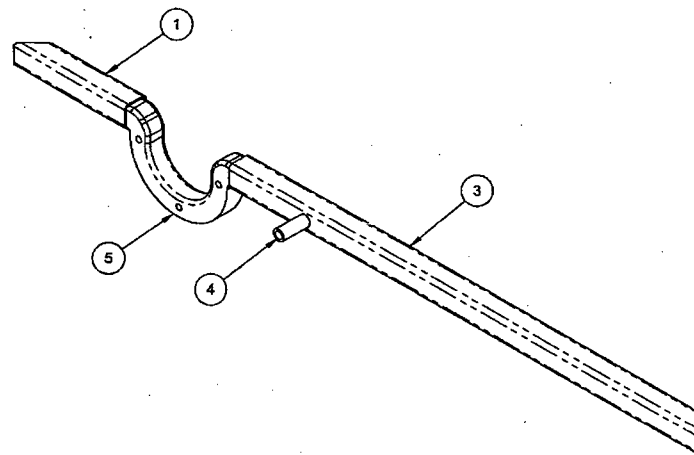
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69157

11-05-7

RELEASED
R 2011-01-18
MS

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

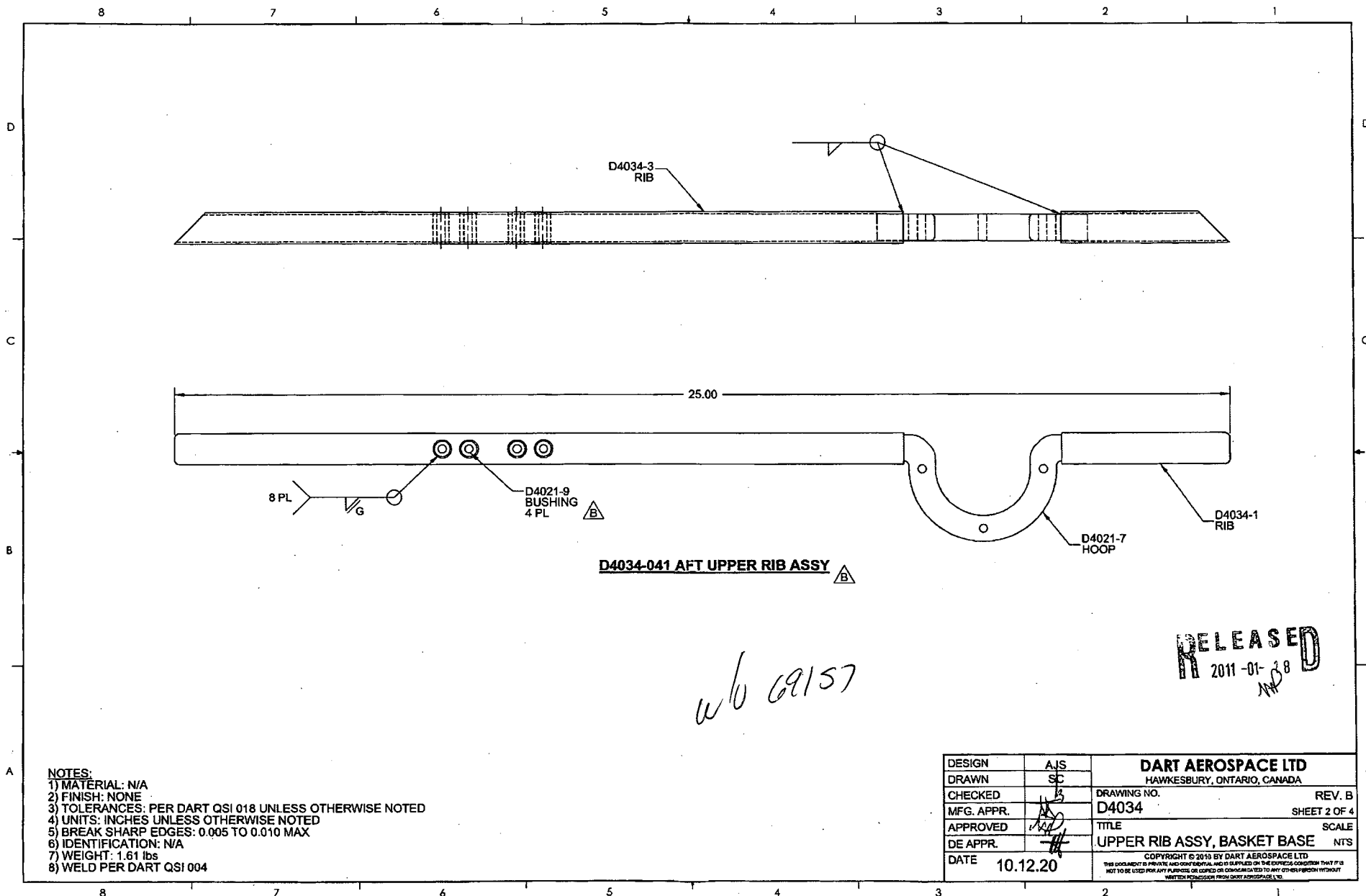
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

0.94

D2327-3
SPACER BUSHING

25.00

D4034-5
RIB

D4021-7
HOOP

D4034-1
RIB

D4034-043 FWD UPPER RIB ASSY

W/O 69157

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1

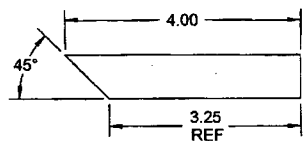
W/O:		WORK ORDER CHANGES						
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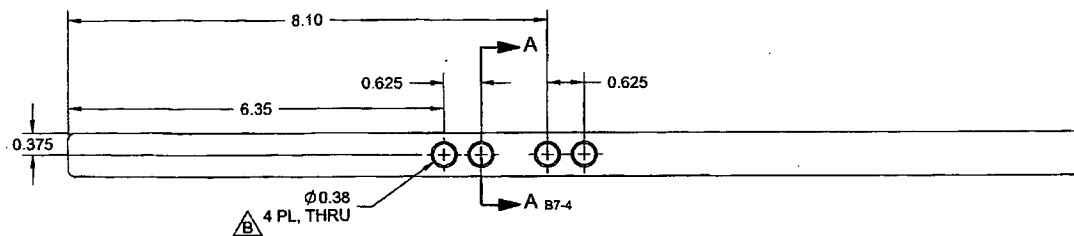


D4034-1 RIB

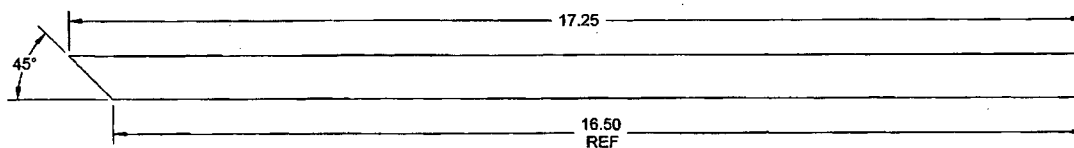
BREAK EDGE
0.030 X 45°
TYP



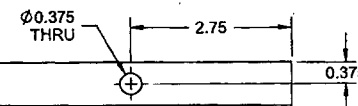
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

W/S 69157

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 4 OF 4
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